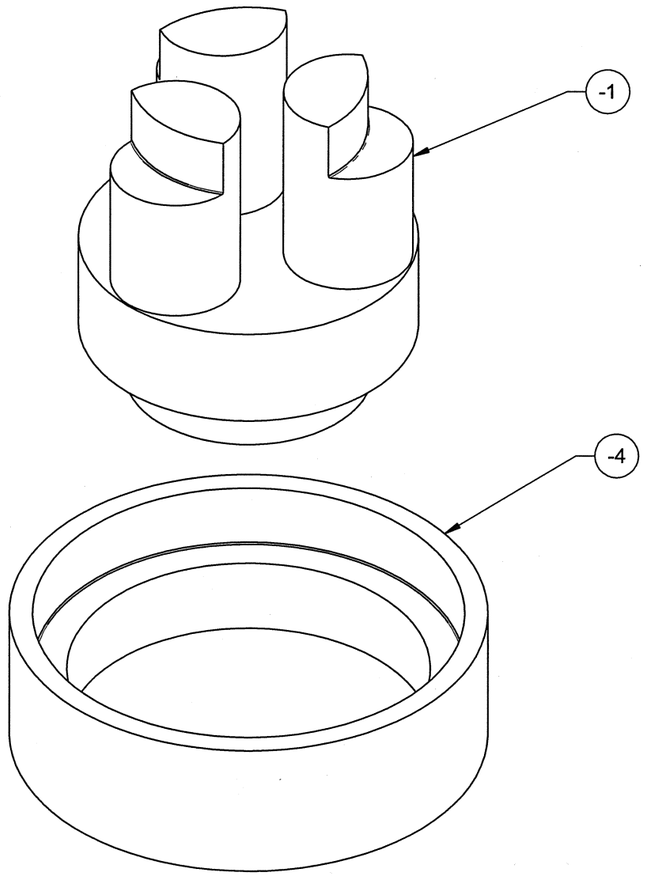
ITEM #	QTY	PART #	PART TITLE
-1	1	RBE350A93-3232-00-1	SEAL HOLDER ASSY
-4	1	RBE350A93-3232-00-4	SEAL RING



RBE350A93-3232-00 SEAL & SEAL HOLDER REPLACEMENT

7

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH:
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

REV.	DESCRIPTION	ECN #	BY
A	SEE PREVIOUS PDF FOR OLDER REV TEMPLATE UPDATED PER DART HAWKESBURY STANDARDS ITEM **-7** CHANGED FOR ITEM **-4** ITEM **-9** McMaster#98381A468 DELETED ITEM **-3** CHANGED FOR ITEM **-2** ITEM **-5** CHANGED FOR ITEM **-3** ITEM **-1** FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, MANUFACTURING PROCESS CHANGED ITEM **-2** DIMENSION 3X .5004/.5000 CHANGED FOR 0.5000 +0 / -0.0008, DIMENSION 3X .1282/.1265 REMOVED, DIMENSION 3X .313 REMOVED, DIMENSION R0.008" MAX ADDED, DIMENSION 1.260 CHANGED FOR 1.260 +0/-0.005", ENGRAVING S/N AND "MADE IN USA" REMOVED AND P/N RBE350A93-3232-10 REPLACED BY RBE350A93-3232-00 ITEM **-3** SLOT .1282/.1265 REMOVED, DIMENSION .250 REMOVED, DIMENSION R0.008 MAX ADDED, DIMENSION .5008/.5005 CHANGED FOR 0.5000 +0.0008/-0, CENTER DRILL NOTE ADDED, MATERIAL SP CHANGED FOR 1144 STRESSPROOF ITEM **-4** MATERIAL SP CAD PLATE CHANGED FOR 1144 STRESSPROOF ZINC PLATE YELLOW, ENGRAVING RBE350A93-3232-20 CHANGED FOR RBE350A93-3232-00, DIMENSION R0.008" ADDED	19-717	VM

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	
DATE	5/1/2019

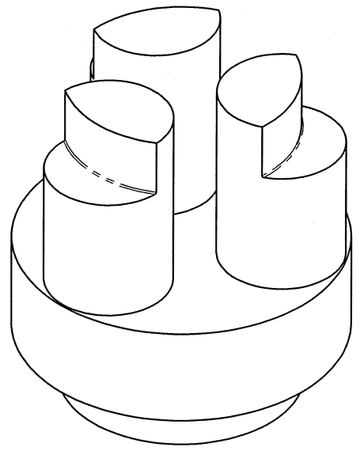
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

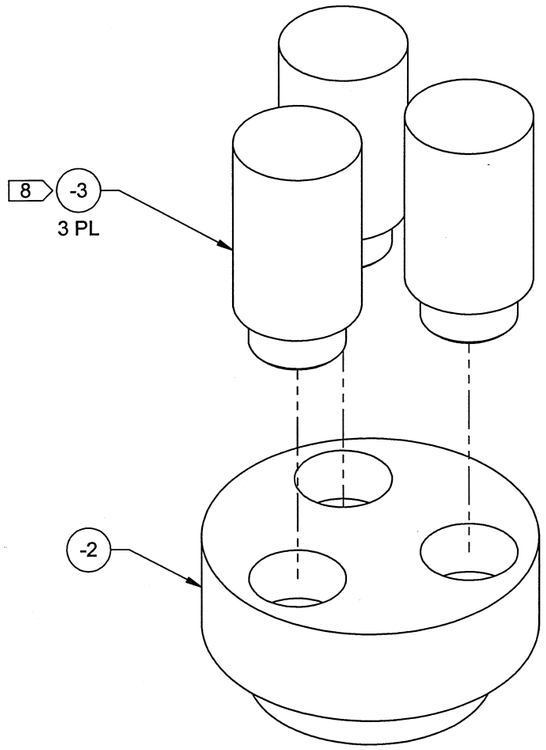
TOOL PART # RBE350A93-3232-00 REV. A
SHEET 1 OF 5

TITLE SEAL & SEAL HOLDER REPLACEMENT SCALE NTS

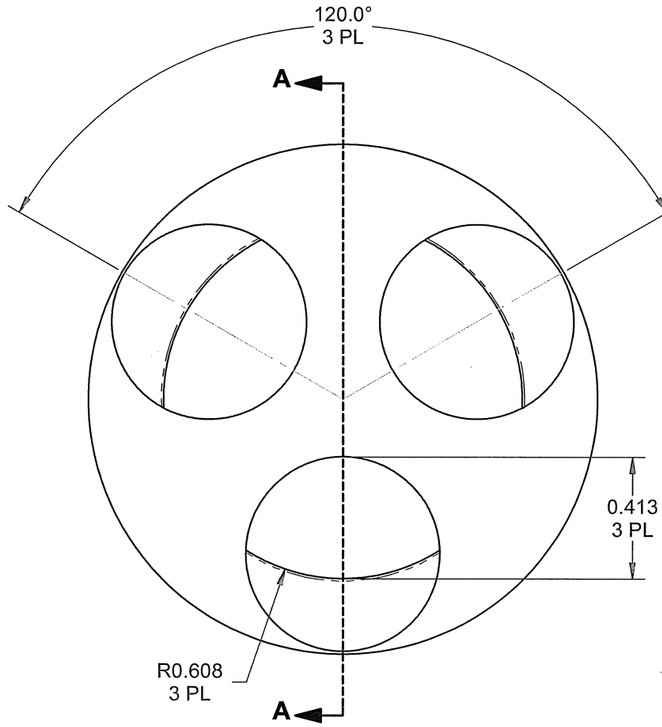
COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

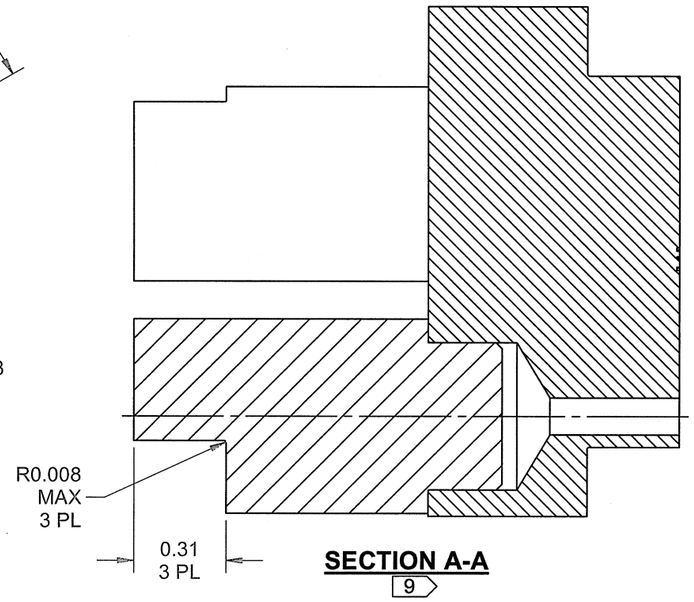
ITEM #	QTY	PART #	PART TITLE
-2	1	RBE350A93-3232-00-2	BASE
-3	3	RBE350A93-3232-00-3	POST





RBE350A93-3232-00-1 SEAL HOLDER ASSY





SECTION A-A
9

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 WITH ITEM -2, AND REMOVE EXCESS
9) AFTER PRESS FIT ITEM -3 WITH ITEM -2, MACHINE AS SHOWN

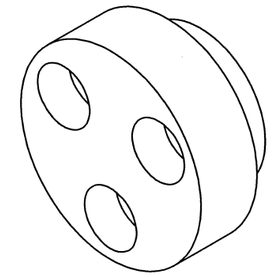
DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	
DATE	5/1/2019

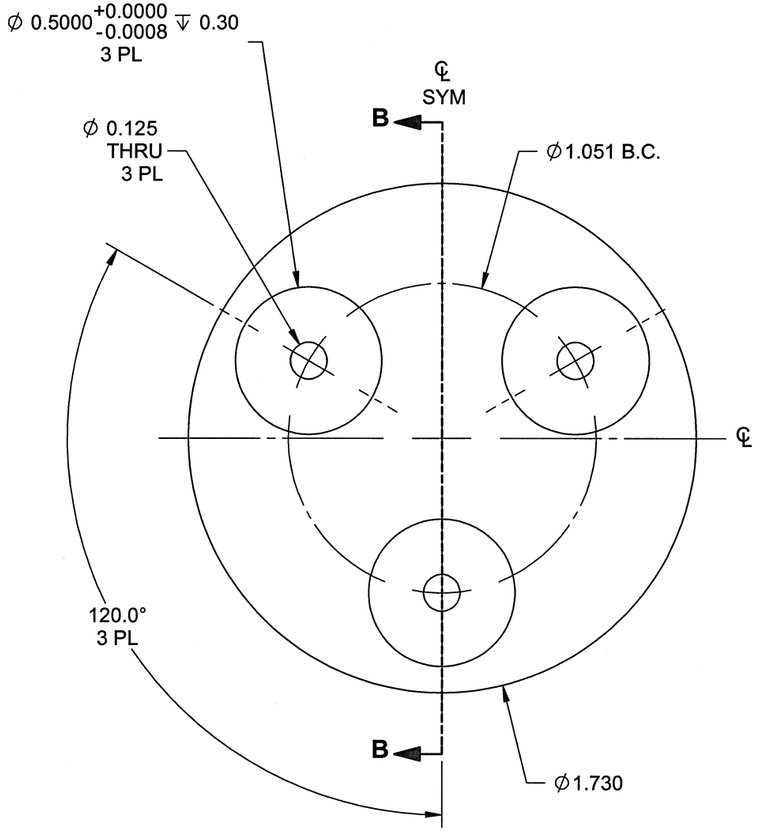
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBE350A93-3232-00 REV. A
SHEET 2 OF 5

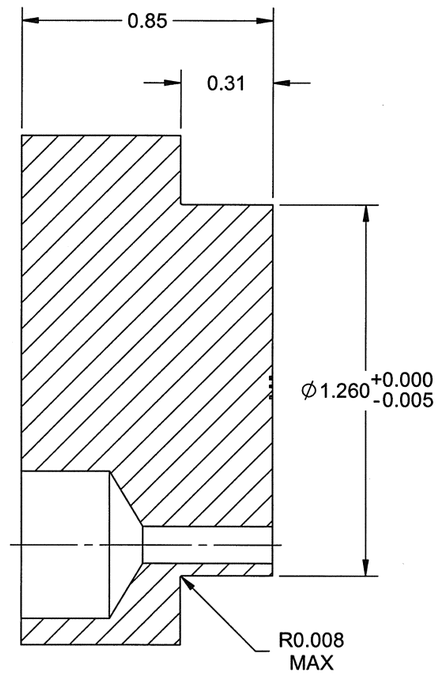
TITLE SEAL & SEAL HOLDER REPLACEMENT SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

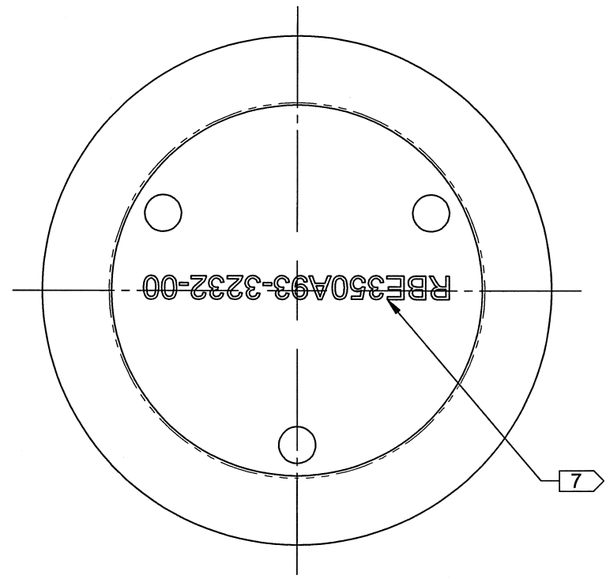




RBE350A93-3232-00-2 BASE



SECTION B-B



NOTES:
1) MATERIAL: 1144 STRESSPROOF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

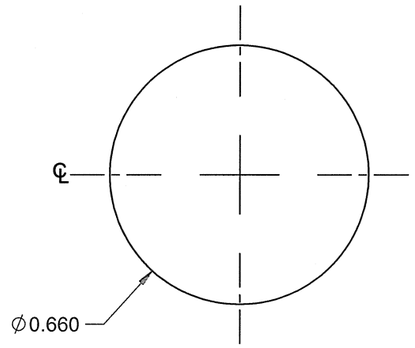
DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	WP
DATE	5/1/2019

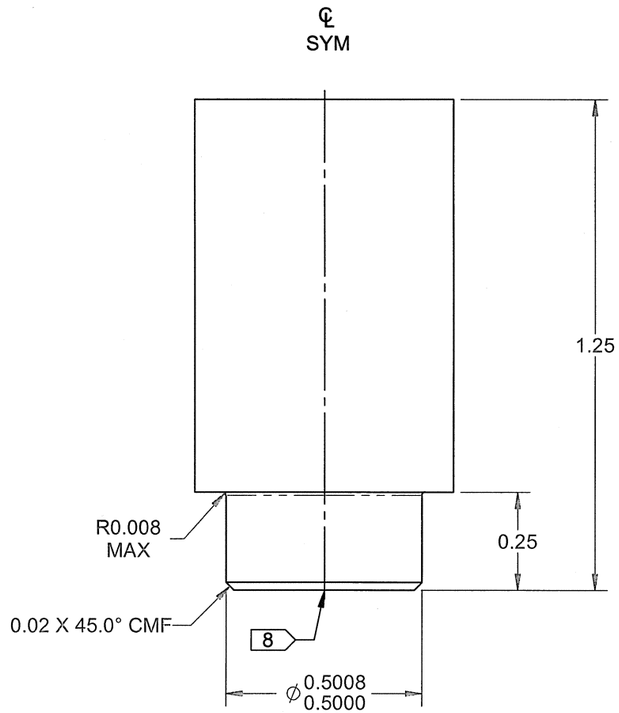
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

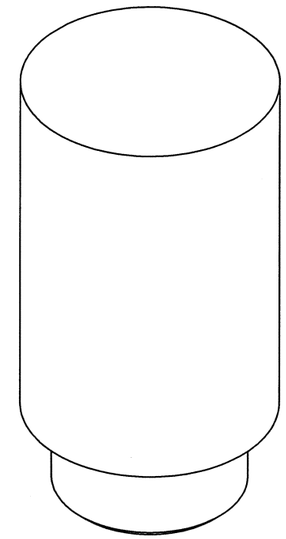
TOOL PART # RBE350A93-3232-00 REV. A
SHEET 3 OF 5

TITLE SEAL & SEAL HOLDER REPLACEMENT SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







RBE350A93-3232-00-3 POST

NOTES:
1) MATERIAL: 1144 STRESSPROOF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

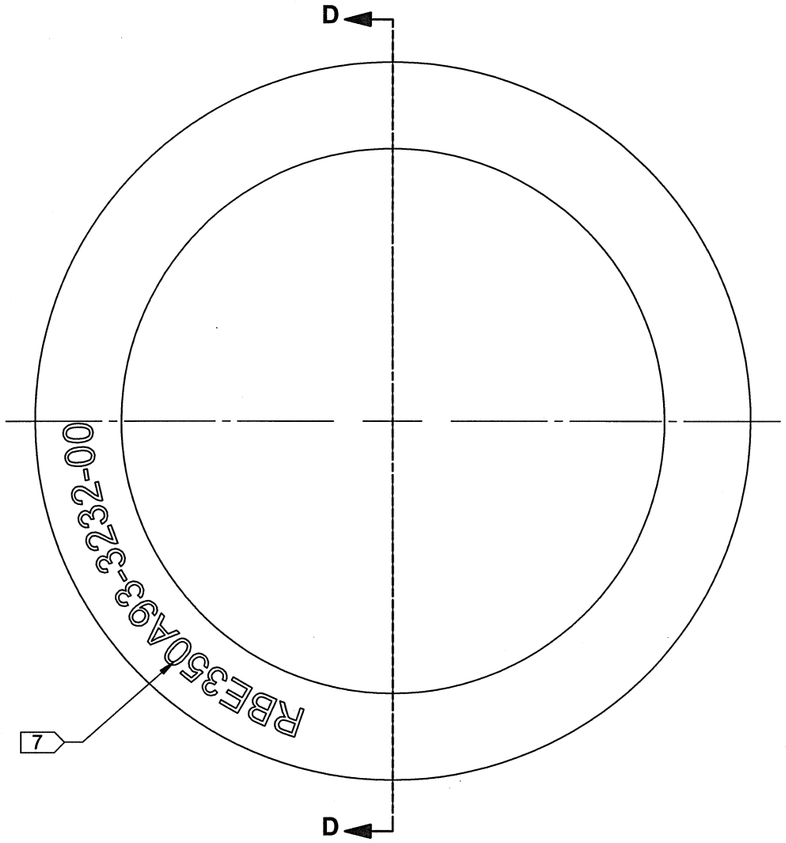
DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	
DATE	5/1/2019

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

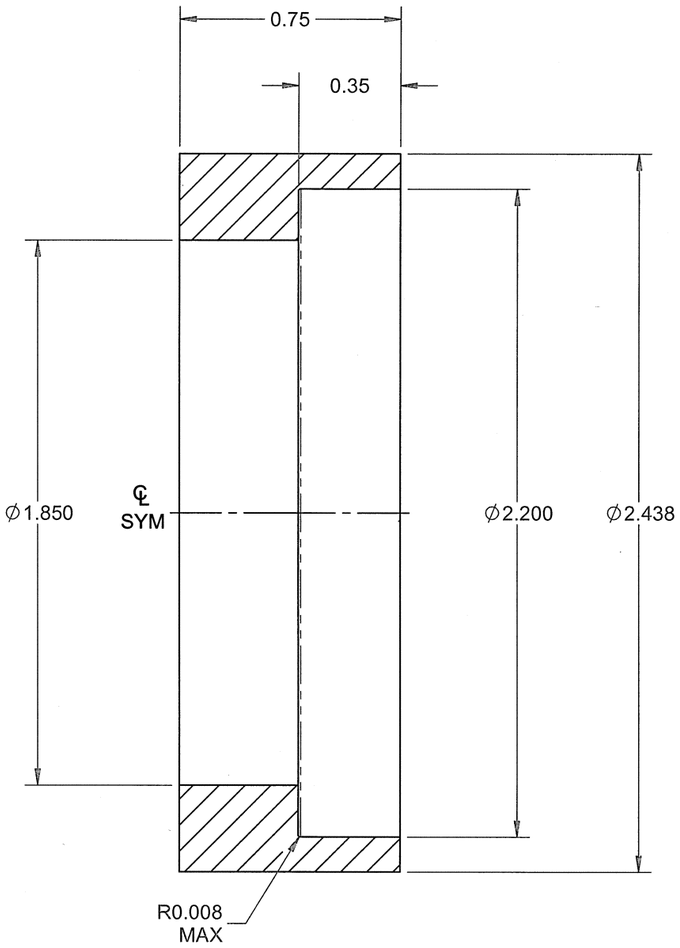
TOOL PART # RBE350A93-3232-00 REV. A
SHEET 4 OF 5

TITLE SEAL & SEAL HOLDER REPLACEMENT SCALE NTS

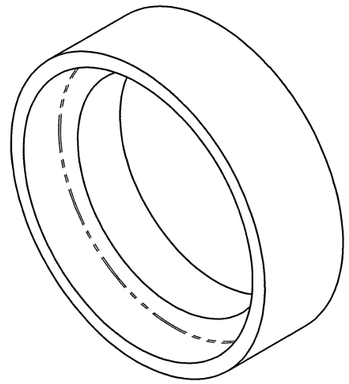
COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RBE350A93-3232-00-4 SEAL RING



SECTION D-D



NOTES:
1) MATERIAL: 1144 STRESSPROOF
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	
DATE	5/1/2019

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBE350A93-3232-00 REV. A
SHEET 5 OF 5

TITLE
SEAL & SEAL HOLDER REPLACEMENT
SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.